

Work Order ID 53465

November 6, 2009 8:23:18 AM



Page 1

Item ID: D2857-2

Accept



Setup Start



Revision ID: B

Stop



Item Name: Hinge Bracket

Start Date: 05/11/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 12.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date:

09/11/19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2857	Rev B								

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 5.2"

2L 09/11/19

12

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio D2857-2 2-Deburr any rough edges

DJP 09/11/20
H.A 09/11/21

12

0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

DJP 09/11/20

12

0

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

5 Nov 11/22

12

✓

Memo

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

all 09/11/23

12

✓

Memo

0.00

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

BR 09-11-23

12

Memo

0.00

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Item ID:	D2857-2	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Hinge Bracket					
Start Date:	05/11/2009	Start Qty:	12.00	Cust Item ID:		
Required Date:	13/11/2009	Req'd Qty:	12.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M1112148 Memo START TIME: 12:30pm <input type="checkbox"/> FINISH TIME: 1:00pm OVEN TEMPERATURE: 320°F	0.00 0.00				12	9		
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							BR 09-11-23
180 Packaging Packaging	Identify as per dwg & Stock Location: 50 Memo	0.00 0.00							9/11/24 12x



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Item ID: D2857-2

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Setup Start



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Item Name: Hinge Bracket

Start Date: 05/11/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/25

PR 09-11-24 (12)

Picklist Print

November 6, 2009 8:23:22 AM

Page 1

Work Order ID: 53465



Parent Item: D2857-2RevB



Parent Item Name: Hinge Bracket

Start Date: 05/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased	No			100	f	30.8000	5.5263			



6061-T6 Bar 2.00 x 1.25

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	30.8	
105838	12	
110936	18.8	

5.526

SL 09/11/09

DART AEROSPACE LTD		Work Order:	53465
Description: Hinge Bracket		Part Number:	D2857-2
Inspection Dwg: D2857	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.310	✓			
4.000	+/-0.010	4.005	✓			
0.340	+/-0.010	0.340	✓			
1.110	+/-0.005	1.108	✓			
1.790	+/-0.010	1.790	✓			
1.320	+/-0.005	1.320	✓			
2.000	+/-0.010	2.002	✓			
0.340	+/-0.010	0.340	✓			
0.447	+/-0.010	0.447	✓			
Ø0.171	+0.005/-0.000	0.173	✓			
0.147	+/-0.010	0.139	✓			
0.376	+/-0.010	0.378	✓			
0.126	+/-0.010	0.125	✓			
0.063	+/-0.010	0.069	✓			
Ø0.166	+0.005/-0.000	0.1665	✓			
0.911	+/-0.010	0.916	✓			
0.600	+/-0.010	0.606	✓			
0.125	+/-0.010	0.126	✓			
0.150	+/-0.010	0.148	✓			

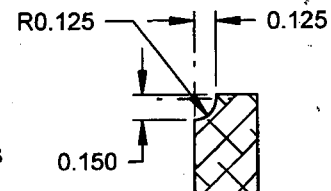
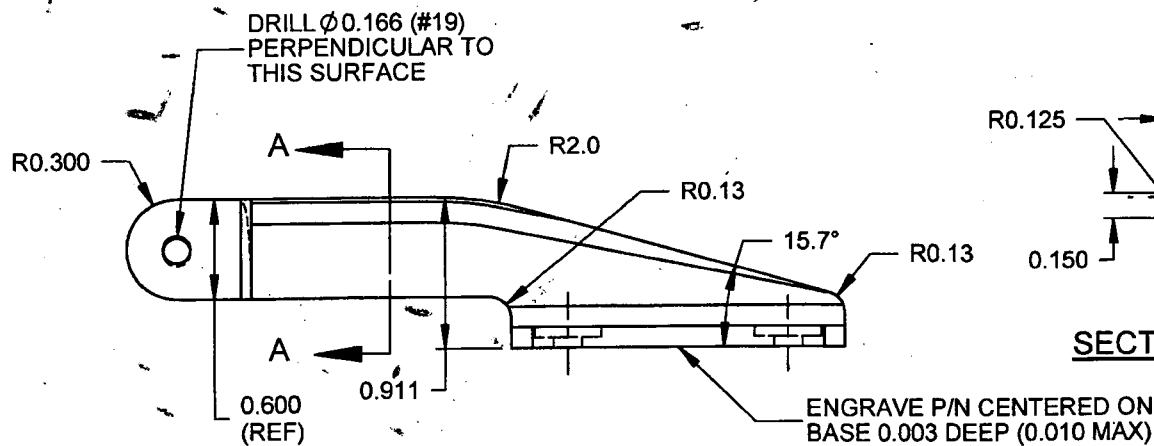
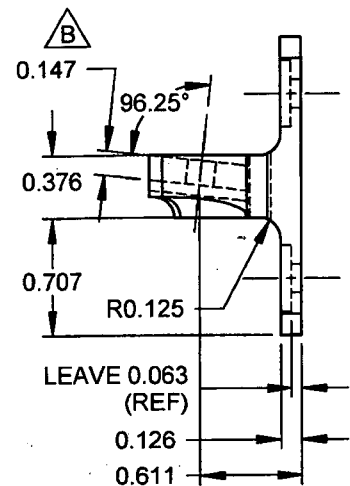
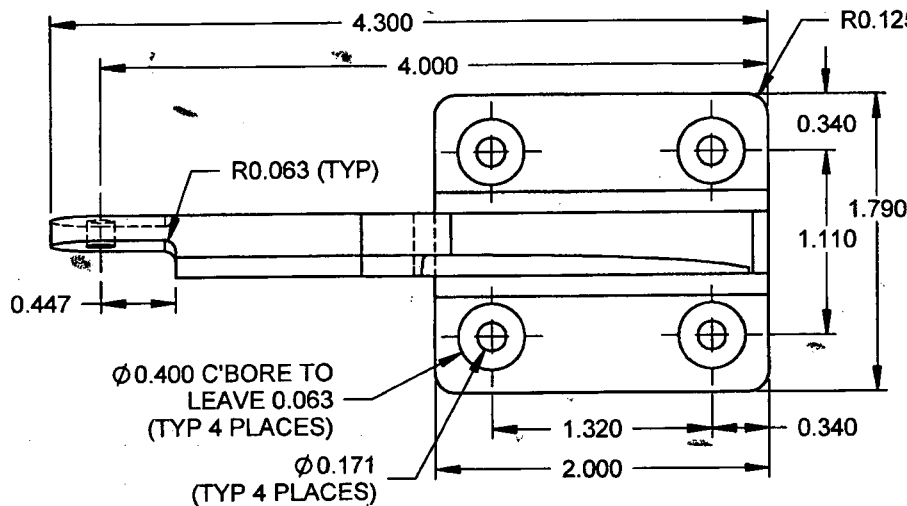
Measured by:	DJP	Audited by:	SA	Prototype Approval:	N/A
Date:	09/11/20	Date:	09/11/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	



DESIGN KE	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2857	REV. B SHEET 1 OF 1
DATE 06.08.28	TITLE HINGE BRACKET		SCALE 1:1
REV	DATE	DESCRIPTION	
A	98.12.14	NEW ISSUE	
B	06.08.28	ADD THICKNESS, REDRAW W/ SOLIDWORKS	

RELEASED
06.10.13

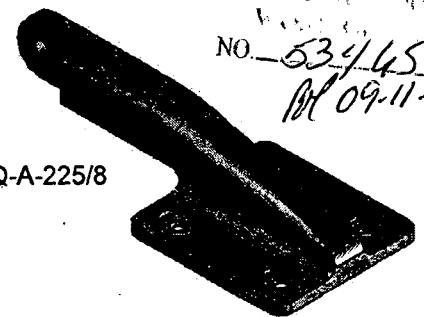


SECTION A-A
SHOP COPY
RETURN TO
ENGINEER
UNCONT
SUBJ
V. 10.10.01
NO. 53445
09.11.05

D2857-1 HINGE BRACKET
D2857-2 OPPOSITE

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



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